

Work Order ID 151461

Tuesday, September 27, 2016 11:53:59 AM

151461

Page 1

Item ID: D3296-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Interior Door For -111
 Start Date: 9/21/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 9/27/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: **DAS 21** Date: **SEP 28 2016** Tooling: Date: Run Start ***NR1***
 QC: **9-89** Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3296	B								
100	Small Fab	0.00							
100									
Small Fab	Memo	0.19							
Small Fab	Fabricate & assemble as per Dwg D3296.								
	Transfer drill using DT8470 & DT9521								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.01							
Quality Control									
120	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
120									
Powdercoat	Memo	0.05							
Powder Coating	START TIME: 2:40 FINISH TIME: 3:10 OVEN TEMPERATURE: 320°								

Pick kit

~~NOV 8 1 2016~~

DAS 6 9-89

4x

DAS 36 9-89
16/12/08

DAS 38 9-89

DEC 09 2016

4 φ 16-12-13. **320°**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				<u>4</u>			 DEC 14 2016
140 *140* Small Fab Small Fab	Small Fab Memo Assemble as per Dwg D3296	0.00 0.10				<u>4x</u>			 16/12/14
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				<u>4</u>			 DEC 14 2016

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Work Order update only ☐

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Description Work Order Deviation				Disposition					
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								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	Pressure/Forced ☐	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	☐ Offset/Setup	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	☐ Supplier	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	☐ Training	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	☐ Use for Testing	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	☐ Poor Information	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	☐ Rushing	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	☐ Product Improvement	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	☐ Process Improvement	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>5436</u>	0.00							
160									
Packaging	Memo	0.01							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.07							
Quality Control									

4 DEC 14 2016 DAS 6 9-89
DAS 21 9-89 DEC 15 2016
MF 16-12-14

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

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				QC / QA Coordinator Approval	
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OTHER : ☐					

Picklist Print

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Work Order ID: 151461

151461

Parent Item: D3296-041

D3296-041

Parent Item Name: Replacement Interior Door For -111

Start Date: 9/21/2016

Required Date: 9/27/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C05.10.14Added step 14KJ/EC
IPP Rev:D Revised Steps 06-11-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2137		Manufactured	No			140	Each	12.0000	1	4			
D2137									**			16/12/14	DAS 36 9-89
Decal(No Step)													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				12				15/6/10	(4X)
				141995				6					
				150061				6	9/7/2017				
D2419		Manufactured	No			140	Each	0.0000	1	4			
D2419												16/12/14	DAS 36 9-89
Handle													
D2462		Manufactured	No			140	f	396.2008	2.8166	11.2664			
D2462									**			16/12/14	DAS 36 9-89
Neoprene Seal (\$Per foot)													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST408				396.2008				11.2664	
				115832				396.2008					
D2728-1		Manufactured	Yes			140	Each	-8.0000	1	4			
D2728-1									**			16/12/08	DAS 36 9-89
Dart Logo Label Small													
D3161-7		Manufactured	No			100	Each	2.0000	1	4			
D3161-7									**			15/14/92	DAS 6 9-89
Hinge 14.0"													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST489				2					
				148303				2					

DEC 07 2016

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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
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Work Order ID: 151461

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Parent Item: D3296-041

D3296-041

Parent Item Name: Replacement Interior Door For -111

Start Date: 9/21/2016

Required Date: 9/27/2016

Start Qty: 4.00

Required Qty: 4.00

D3161-9 Manufactured No

100 Each 2.0000 1 4

D3161-9

Hinge 17.0"

****** 151522 DEC 05 2016

DAS 6 9-89

Location Loc Qty Loc Code

ST483 2
148340 2

D3296-1 Manufactured No

100 Each 4.0000 1 4

D3296-1

Door Panel

****** 157765x2 DEC 05 2016

DAS 6 9-89

Location Loc Qty Loc Code

ST494 4
147951 4

D3296-3 Manufactured No

100 Each 5.0000 1 4

D3296-3

Door Panel

****** 157739

DEC 05 2016

DAS 6 9-89

Location Loc Qty Loc Code

ST494 5
148263 5

MS20470AD4-4 Purchased No

140 Each 4,037.000 25 100

MS20470AD4-4

Rivet, Universal Head

16/12/08 DAS 36 9-89

Location Loc Qty Loc Code

CCK004 2069.931
M135133 0.931
M135536 2069
GA 1599.069
M134294 101
M134848 378
M135133 1120.069
ST310 368
M132803 368

M136042
100x

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Shop Packet Print

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Required Date: 9/27/2016

Start Qty: 4.00

Required Qty: 4.00

MS20470AD4-6

Purchased

No

100

Each

2,268.000

1

4

MS20470AD4-6

Rivet, Universal Head

16/12/14 DAS 36 9-89

Location

Loc Qty

Loc Code

CCK004

1566

m134852

1566

GA

497

m131618

81

m133077

416

ST310

205

m134360

205

4

NAS1149DN632J

Purchased

No

140

Each

499.0000

1

4

NAS1149DN632.J

Washer

DAS 6 9-89 DEC 05 2016

Location

Loc Qty

Loc Code

ST265

499

m134370

499

4

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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																																																																										
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																																																																										
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																										
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																																																																										
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																										
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																										
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																										
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																										
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																										
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																										
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																																																																													
Misidentified ☐	Past Due ☐																																																																														